Work Order ID 96665

January-30-13 1:26:29 PM

96665

Item ID: D2236
Revision ID:
Item Name: Lid Rib

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 1/30/13 **Start Qty:** 8.00 *8*
Required Date: 2/13/13 **Req'd Qty:** 8.00 *8*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** MLS **Date:** 13-01-30 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2236	**Revision Nbr** C								
100	Large Fab	0.00							
100 Large Fab Large Fab	**Memo** 1- Pick D3166-3 and cut use DT8303 2- Remove identification markings on tube 3- Deburr	0.00							
110	QC6- Inspect dimensions to drawing	0.00							
110 QC Quality Control	**Memo**	0.00							

HK 13-01-30

PC 13-1-29

4

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 96665

January-30-13 1:26:30 PM

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Item ID: D2236
Revision ID:
Item Name: Lid Rib

Start Date: 1/30/13 **Start Qty:** 8.00 *8*
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Reference:

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Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location:_____	0.00							
120 Packaging	**Memo**	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130 QC	**Memo**	0.00							
Quality Control									

13-01-30

13/1/31

13-01-31

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
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Supplier	☐									
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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

January-30-13 1:26:33 PM

Work Order ID: 96665

96665

Parent Item: D2236

D2236

Parent Item Name: Lid Rib

Start Date: 1/30/13 **Required Date:** 2/13/13

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP REV:A 12.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3		Manufactured	No			100	Each	7.6605	1	8			

D3166-3

Basket Hoop

**

86824 → 1x

SY 13-01-30

Location		Loc Qty	Loc Code
WA004		7.2216646	
	81578	0.1052	
	86824	2.1480526	
	87793	2	
	92169	2.968412	
WA007		0.4388	
	77294	0.4388	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

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- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

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Doc/Data	☐									
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- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

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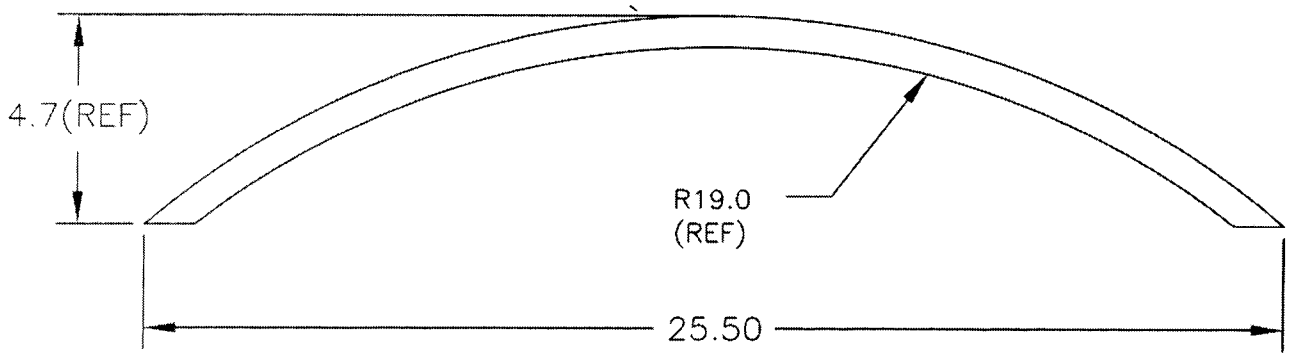
_____

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	PH	
CHECKED	APPROVED	DRAWING NO. REV. C
		D2236 SHEET 1 OF 1
DATE		TITLE SCALE
05.06.07		LID RIB 1:4

A	94.05.30	NEW ISSUE
B	94.12.16	LID
C	05.06.07	UPDATE NOTES,CHANGE RADIUS TO 19.0

RELEASED
05-08-19



D2236

D2236 LID RIB

1) MAKE FROM D3166-3 BASKET HOOP
2) FINISH: NONE
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

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Scrap	☐
Use-as-is	☐
Work Order Update	☐

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Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
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☐	Over/Under tolerance
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☐	Temperature/Cure
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☐	Other

_____

_____

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